

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75807

75807

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October-31-11 12:39:34 PM

Item ID: D3238-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plate
Start Date: 31/10/2011 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 09/11/2011 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as per Dwg D3238Dwg Rev: <u>C</u> if necessary	0.00 0.00							
						<u>B11-11-7</u>			<u>(18)</u>
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							
						<u>B11-11-7</u>			
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
						<u>(4/8)</u>			<u>8/11/10/7</u>

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Page 3

October-31-11 12:39:34 PM

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>18</u>	<u>BR</u>	<u>11-11-8</u>	
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>072</u> Memo	0.00 0.00							

18X of M-11/11/08

Pepper 18

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75807

October-31-11 12:39:34 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 31/10/2011 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 09/11/2011 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number.

**Insp.
Stamp**

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

Number Stamp
11/11/89

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Picklist Print

October-31-11 12:39:38 PM

Page 1

Work Order ID: 75807

75807

Parent Item: D3238-1

D3238-1

Parent Item Name: Plate

Start Date: 31/10/2011

Required Date: 09/11/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-10-20 EC
IPP Rev:B Now on Waterjet 07-01-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.080

Purchased

No

100

sf

208.8000

0.012

0.151579

5

M2024T3S 080

**

B11-3

2024-T3 .080 sheet

B11-11-7

Location

Loc Qty

Loc Code

MAT022

208.8

105411

6

109424

4

110347

0.5

112331

3

113796

7

114025

15.7

116604

5.8

117392

40.1

118180

49.7

119117

77

119117

(17)

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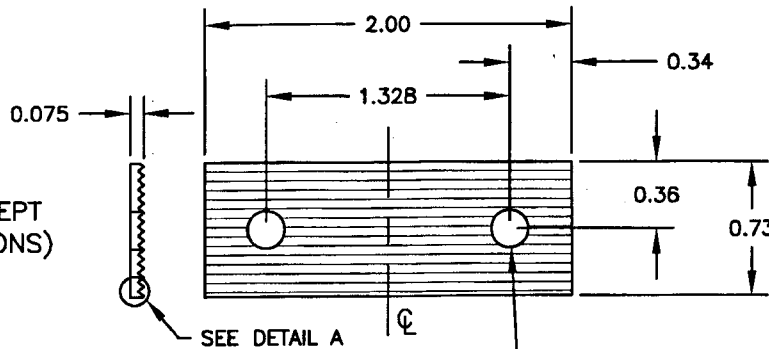
NOTE: Date & initial all entries

DART

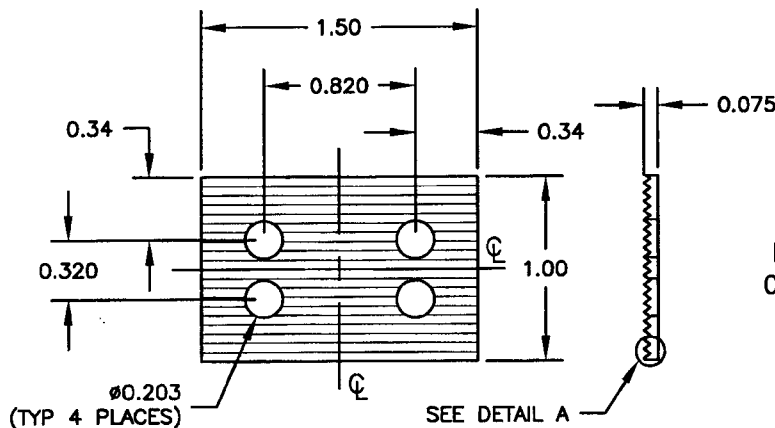
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20

D3238-1 PLATE (SHOWN)D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)Ø0.203
(TYP 2 PLACES)SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35807 M-LJ

11/10/31

D3238-3 PLATE (SHOWN)D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)Ø0.203
(TYP 4 PLACES)**NOTES:**

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT ϕ

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

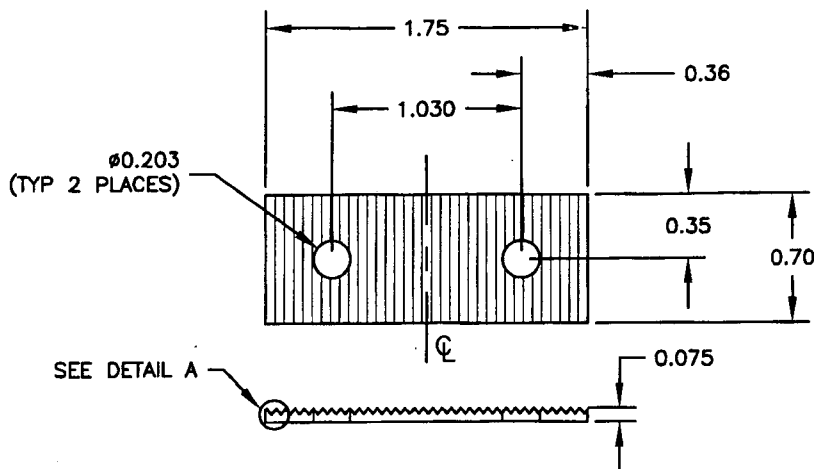
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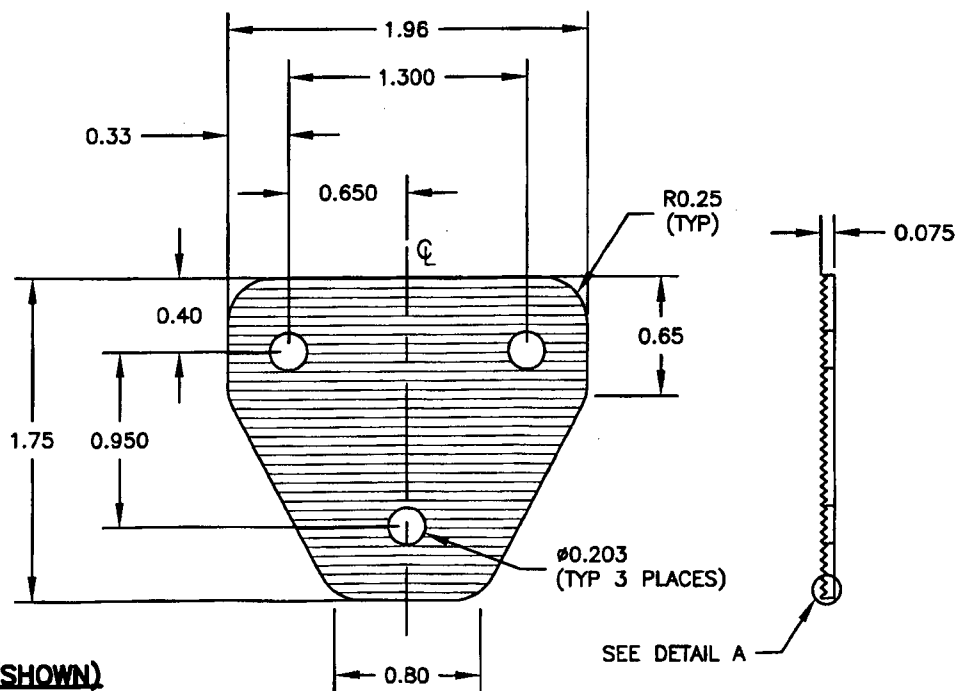
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CHECKED CE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1



RELEASED
07.02.20 #

D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

7500X



D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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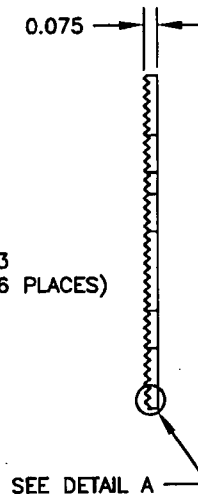
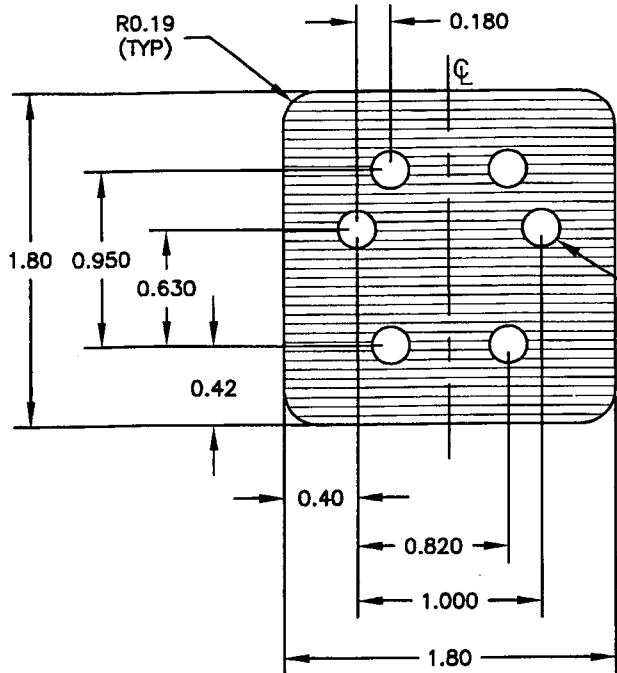
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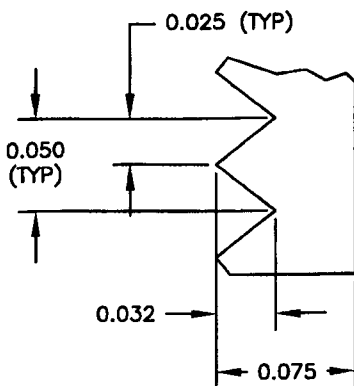
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1



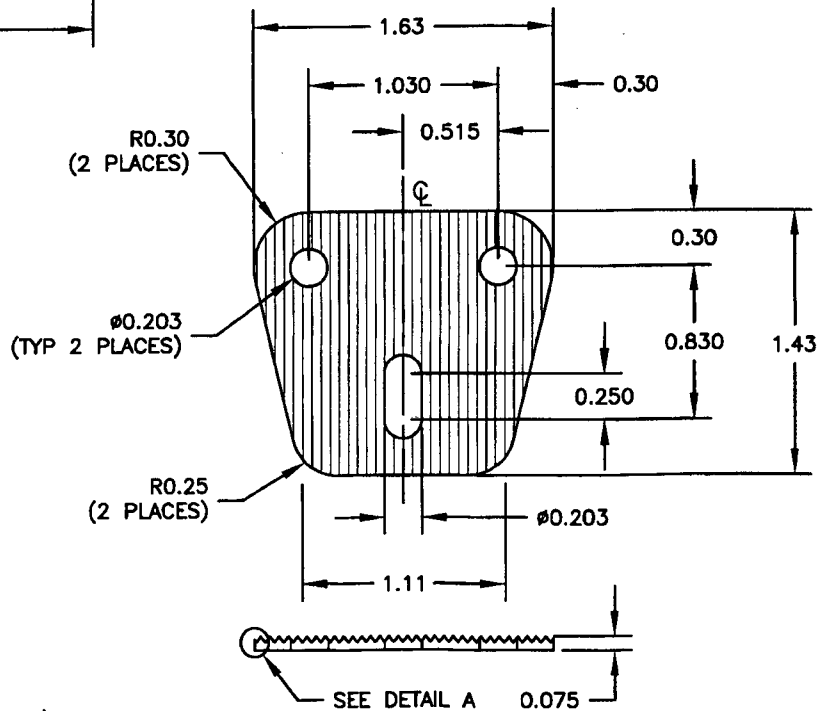
RELEASED
07.02.20

D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

7500X



DETAIL A
RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1



D3238-25 PLATE (SHOWN)
D3238-35 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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